

Date: Tuesday, 30/09/2008 8:55:57 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 42352
 Estimate Number : 10532
 P.O. Number :
 This Issue : 30/09/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 41556
 Written By :
 Checked & Approved By : JUD 08.9.30
 Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF

Drawing Name : SADDLE KIT
 Part Number : K10003
 Drawing Number : 634, 635 IIN
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 15/10/2008

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



for JUD 08.11.28



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003 CHG 006

8 08/12/02

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D2570 Bushing



Comment: Qty.: 24.0000 Each(s)/Unit Total : 144.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	<i>39805</i>

SS 08/12/01 (x6)

4.0 D2571 Saddle, Fwd Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	<i>42359</i>

SS 08/12/01 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:55:57 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 42352

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2572 Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	41704

SS 08/12/01 (x6)

6.0 D2573 Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	41589

SS 08/12/01 (x6)

7.0 D2574 Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	41706

SS 08/12/01 (x6)

8.0 D27361 Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	39841

SS 08/12/01 (x6)

9.0 D27363 Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	39223

SS 08/12/01 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: SADDLE KIT

Job Number: 42352

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation: Description :

10.0 D2747 Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 24.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	B39224

SS 08/12/01 (x6)

11.0 D2876 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	B38662

SS 08/12/01 (x6)

12.0 D2877 Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	B39125

SS 08/12/01 (x6)

13.0 D35331 Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s)

Set Screw

Batch:

41606

SS 08/12/01 (x6)

14.0 AN46A Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 96.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	M108558

SS 08/12/01 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SADDLE KIT

Job Number: 42352

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation: Description :

15.0 AN446A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 24.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

4

AN4-46A

Bolt

M108246

SS 08/12/01 (x6)

16.0 AN451A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN4-51A

Bolt

M108376

SS 08/12/01 (x6)

17.0 AN612A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Bolt

Pick:

Qty

Part Number

Description

Batch

8

AN6-12A

Bolt

M109545

SS 08/12/01 (x6)

18.0 AN960JD416 Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 192.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

32

AN960JD416

Washer

M109249
M108827x64

SS 08/12/01 (x6)

19.0 AN960JD616 Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

8

AN960JD616

Washer

M109371
M108145

SS 08/12/01 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 42352

Part Number: K10003

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 MS21042L4 Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 174.0000 Each(s)

Nut

Pick:

Qty Part Number Description Batch
29 MS21042L4 Nut (or MS21042-4) M108145

SS of 11/01 (x6)

21.0 D3407045 Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Tow Ring

batch: 42438 y4

SS 08/11/28 (x6)

22.0 D34561 Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Washer

batch: 40285

SS 08/11/28 (x6)

23.0 MS210434 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

batch: M109166

SS 08/11/28 (x6)

24.0 D34175 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: 41060 x9

All same batch.

SS 08/11/28 (x6)

25.0 D38121 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Washer

batch: 41060 x9 43283

SS 08/11/28 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 30/09/2008 8:55:57 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 42352

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

50812/02 @

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Rev I*

Label checked

880812/02 @

28.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

0812/02

Job Completion



MF 08-12-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

CAUTION:

Over-torquing the nuts or not torquing the nuts in the correct numerical order could lead to saddle structural damage.

NOTE:

After torquing the bolts per Table 1, it is acceptable to have a gap between the saddles and the spacer that is installed between the saddles.

- 3.1.9 Apply a continuous bead of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant in the following locations as per Figure 1:

- A) Along saddle/crosstube interface.
- B) Between the saddle flanges.
- C) Along saddle/skidtube interface.

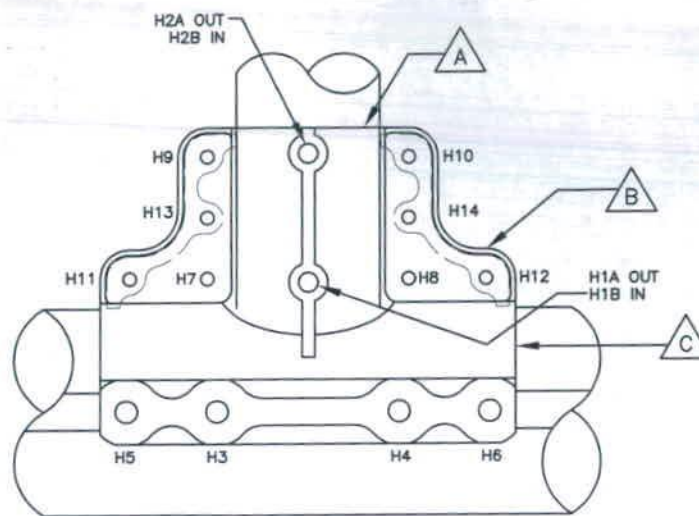


Figure 1 – Saddle Installation

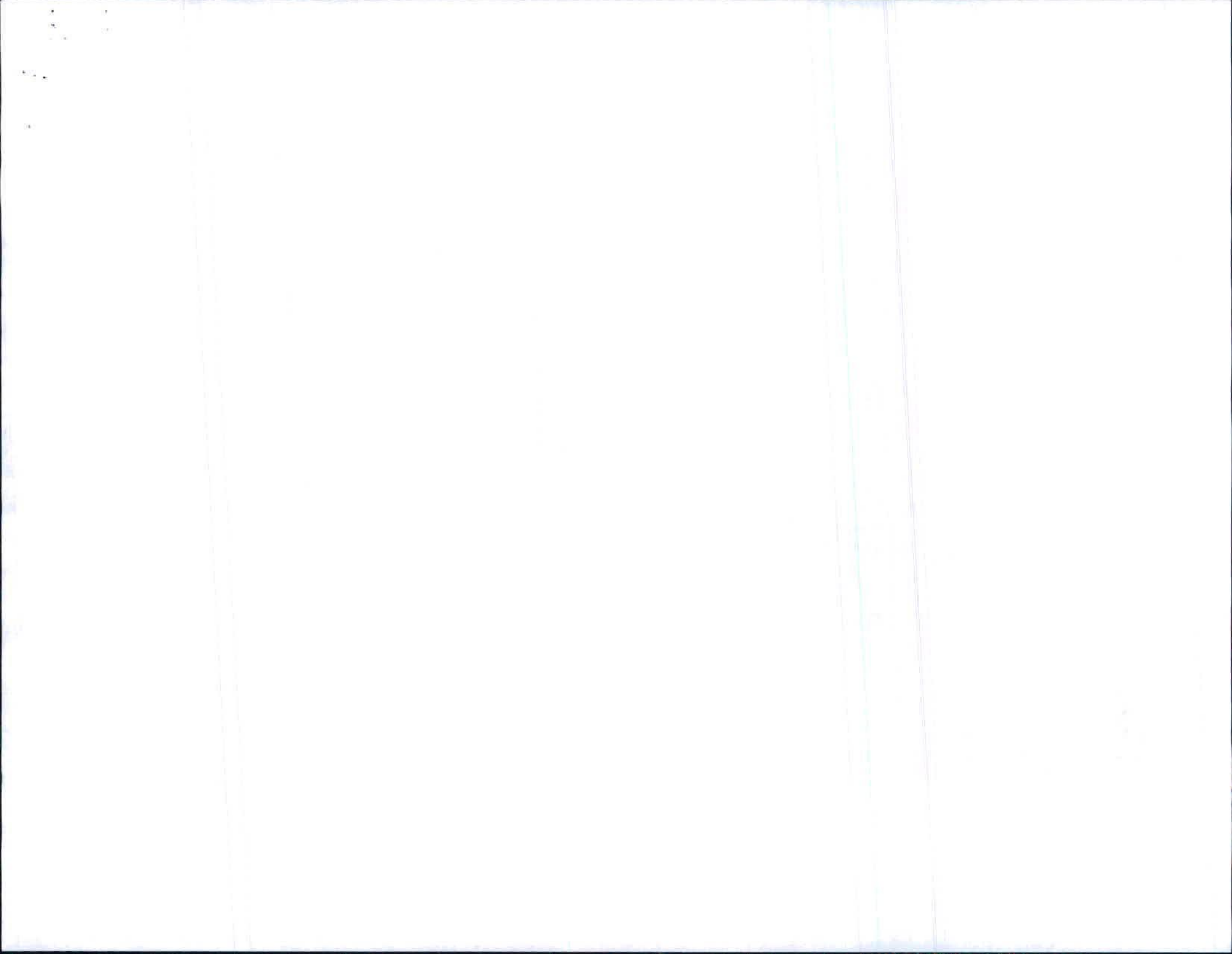
Bolt	Bolt Size	Torque on Nut
H1A	AN6	95-110 IN-LBS (10.7-12.4 N-m)
H1B	AN6	95-110 IN-LBS (10.7-12.4 N-m)
H2A	AN6	95-110 IN-LBS (10.7-12.4 N-m)
H2B	AN6	95-110 IN-LBS (10.7-12.4 N-m)
H3	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H4	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H5	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H6	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H7	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H8	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H9	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H10	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H11	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H12	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H13	AN4	50-70 IN-LBS (5.7-7.9 N-m)
H14	AN4	50-70 IN-LBS (5.7-7.9 N-m)

Table 1 – Maximum Torque on saddle nuts

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NO. 42352

Revision: E
Date: 08.04.15



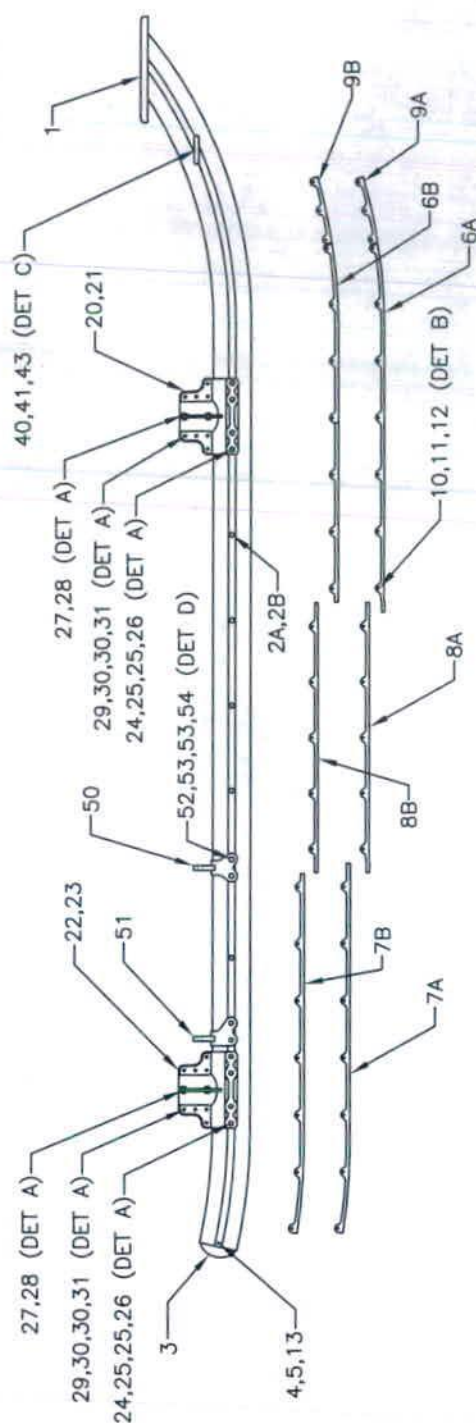


FIGURE 2 - D204-635-011 SKIDTUBE INSTALLATION

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Revision: E
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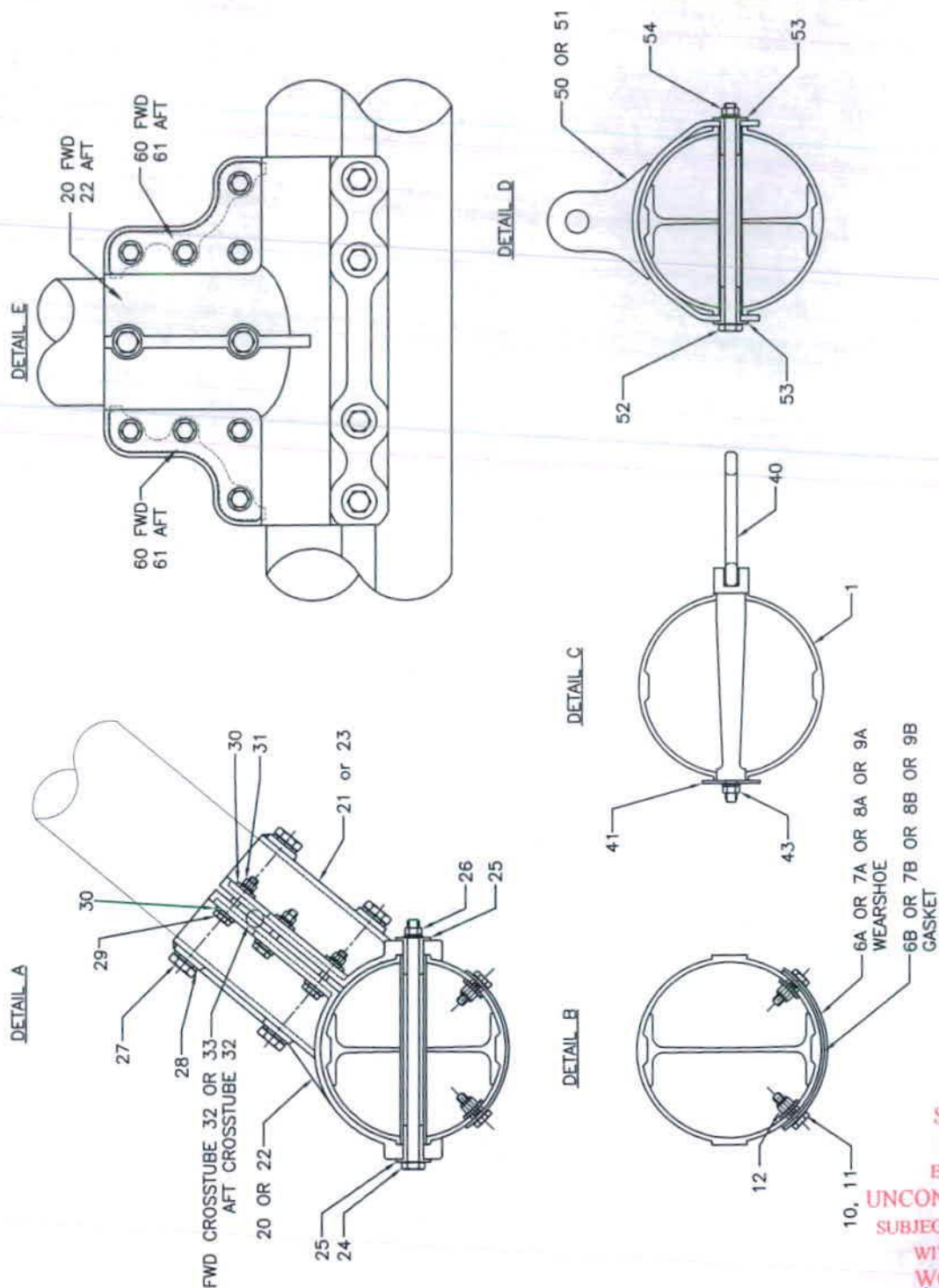


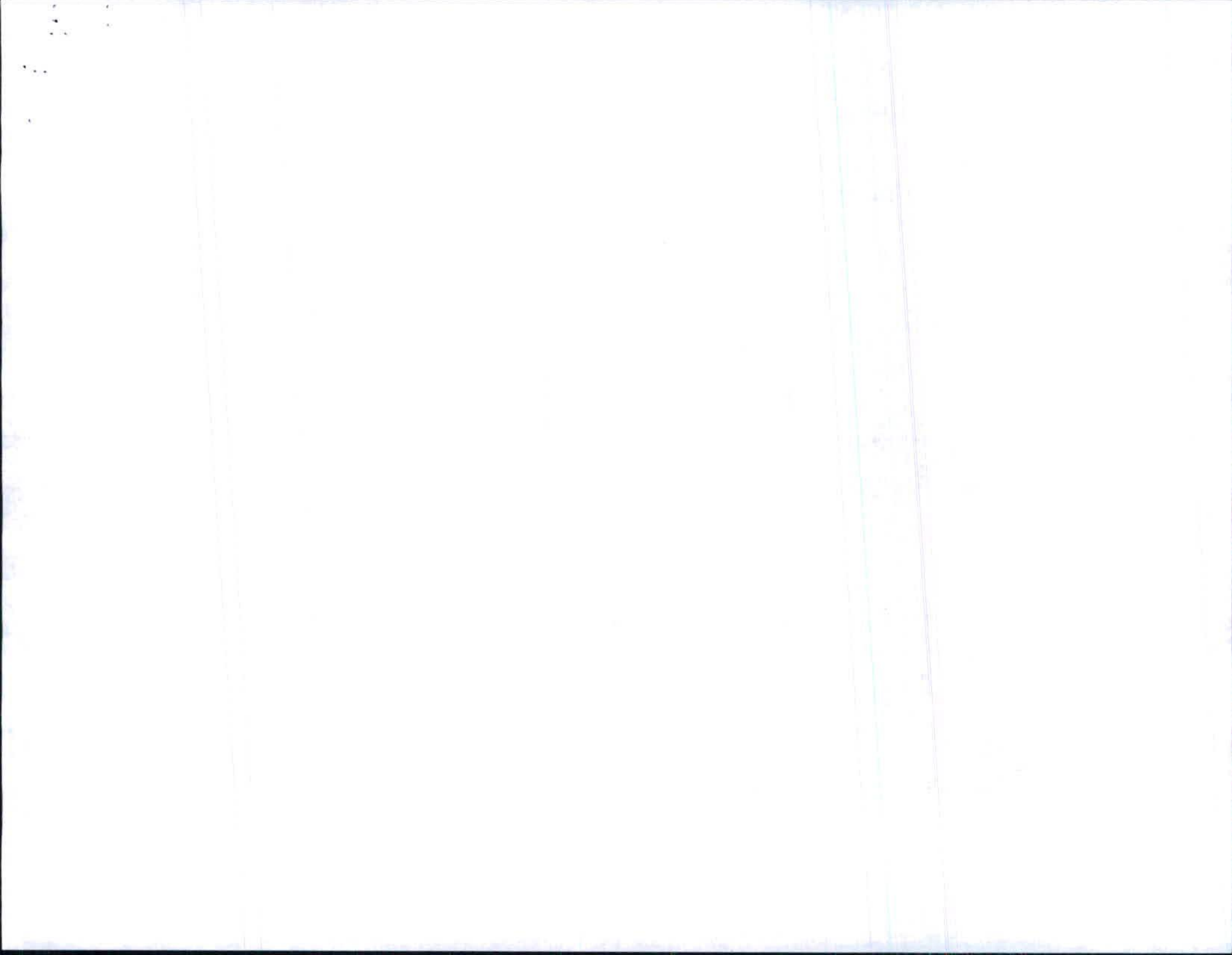
FIGURE 3 - D204-635-011 DETAILS

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Revision: E
Date: 08.04.15



4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart skidtube and saddle installations only. The weight and balance of the skidtube and saddle installations that are being removed from the aircraft are the responsibility of the installer.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D204-635-011 Skidtube Installation (High Gear)	36.9 lb 16.7 kg	± 55 in ± 1.40 m	± 2030 lb-in ± 23.4 kg-m	102.7 in 2.61 m	3790 lb-in 43.6 kg-m
D205-641-011 Ground Handling Kit (High Gear)	2.1 lb 1.0 kg	± 55 in ± 1.40 m	116 lb-in 1.4 kg-m	149.7 in 3.80 m	314 lb-in 3.8 kg-m
D204-635-011 Skidtube Installation (Standard Gear)	36.9 lb 16.7 kg	± 50 in ± 1.27 m	1845 lb-in 21.2 kg-m	102.7 in 2.61 m	3790 lb-in 43.6 kg-m
D205-641-011 Ground Handling Kit (Standard Gear)	2.1 lb 1.0 kg	± 50 in ± 1.27 m	105 lb-in 1.3 kg-m	149.7 in 3.80 m	314 lb-in 3.8 kg-m

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Revision: **E**
Date: 08.04.15



5.0 D204-635-011 SKIDTUBE INSTALLATION PARTS LIST

Item	635 -011	635 -041	641 -011	Part Number	Description
	X			D204-635-011	SKIDTUBE INSTALLATION
	1	X		D204-635-041	SKIDTUBE
	1		X	D205-641-011	GROUND HANDLING KIT
1		1		D2590-041	204 SKIDTUBE ASSEMBLY
2A		10		D2594-1	* PLUG
2B		10		D2594-3	* O-RING
3		1		D2855	* AFT CAP
4		2		AN3-5A	* BOLT
5		2		AN960JD10L	* WASHER
6A		1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B		1		D3566-1	* GASKET
7A		1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B		1		D3566-1	* GASKET
8A		1		D3564-7	* WEARSHOE (REPLACES D2577-7)
8B		1		D3566-7	* GASKET
9A		1		D3564-13	* WEARSHOE
9B		1		D3566-13	* GASKET
10		44		AN3C4A	* BOLT (REPLACES AN3-4A)
11		44		AN960C10L	* WASHER (REPLACES AN960JD10L)
12		44		ALS4-1032-130	* INSERT
13		2		ALS4-1032-225	* INSERT
20	1			D2571	SADDLE, FWD OUTSIDE
21	1			D2572	SADDLE, FWD INSIDE
22	1			D2573	SADDLE, AFT OUTSIDE
23	1			D2574	SADDLE, AFT INSIDE
24	8			AN4-51A	BOLT
25	16			D2570	BUSHINGS
26	8			MS21042L4	NUT (OR MS21042-4)
27	8			AN6-12A	BOLT
28	8			AN960JD616	WASHER
29	16			AN4-6A	BOLT
30	32			AN960JD416	WASHER
31	16			MS21042L4	NUT (OR MS21042-4)
32	4			D2747	SET SCREW
33	2			D3533-1	SET SCREW
40	1			D2968-041	TOW RING
41	1			AN970-4	WASHER
43	1			MS21042L4	NUT (OR MS21042-4)
50			1	D2736-1	GHW LUG
51			1	D2736-3	GHW LUG
52			4	AN4-46A	BOLT
53			8	D2570	BUSHING
54			4	MS21042L4	NUT (OR MS21042-4)
60	2			D2876	SADDLE SPACER
61	2			D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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